

Work Order ID 74232 LH

Wednesday, September 28, 2011 9:49:41 AM



Page 1

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 11-09-28 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

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Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

> DP

11-10-15

SAD 11-10-21 ①

SAD 11-10-28 ①

SAD 11-10-31 ①

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

SAD 11-10-31 (1)

DC 11/10/31

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

11 10 31 (1)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 Skidtubes Skidtubes	Skidtubes Memo 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube	0.00 0.00							

DC 11/10/31

DP 11-11-1

7 DC 11/11/01

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control



11-11-1

180

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

OK 11/11/01

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: ☒ 11/11/01 ☐ Time: ☒ 9:05 ☐

Finish Date: ☒ 11/11/02 ☐ Time: ☒ 10:30 ☐

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Sikaflex-291 ☒ 119399 ☐

Sikaflex expire date: ☐ 12/08/13

OK 11/11/01

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/11/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200



Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☒ ~~74162~~ M117884

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☒ NONE BE 11/11/02

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 11/11/02

DP 11-11-2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 - 11 - 03 ①

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BL 11-11-4

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45
320°F
2:15

IX of m 11/11/07

M118439

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 10

Abstract

Abstract

Reference:

[illegible]

•

**Insp.
Stamp**

Int'l p. l. ulolog

Quality Control

Memo

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date:	10/3/2011	Start Qty:	1.00			
Required Date:	11/4/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	HandFinishing	0.00							
	HandFinish								
Hand Finishing	<div>Memo</div> <div>1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive</div> <div>A/R<input type="checkbox"/> Sikaflex-291<input type="checkbox"/> 11/19/11</div> <div>Sikaflex expire date:<input type="checkbox"/> 12/01</div> <div>2- Install wearplate as per dwg</div> <div>2-Wing Walk as per Dwg D3804 and QSI 005 4.4</div> <div>Batch: 1118988</div>	0.00				164	8	11/19/11	
290	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	<div>Memo</div>	0.00							

8/11/10

164 8 11/11/09

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

300

QC5- Inspect part completeness to step on W/O

0.00

8/11/10



QC

Memo

0.00

Quality Control

310

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PPP 75552

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/10

11/11/11

ME 11-11 10-

W/O:		WORK ORDER CHANGES						
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Picklist Print

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Page 1

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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured No

110

Each

23.0000

1

1



Skidtube, 206 Skidtube



Location

Loc Qty

Loc Code

LG

73782

23

71616

5

71617

6

73781

5

73786

3

73787

4

①

11-10-15

D2647

Manufactured No

110

Each

236.0000

1

1



Cap



Location

Loc Qty

Loc Code

LG002

236

55352

8

71171

28

73826

200

BEU/10/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

10,771.00

52

52



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

771

116471

78

117816

179

118686

1

118840

513

ST516

10000

119017

10000

D2654-1

Manufactured

No

180

Each

10.0000

1

1



Web



Location

Loc Qty

Loc Code

LG

10

73789

10

D3286-1

Manufactured

No

180

Each

80.0000

2

2



Doubler



Location

Loc Qty

Loc Code

LG002

80

64563

6

74111

74

B74441

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

1,983.000

19

19



Cross Bolt Spacer



Bea/10/02

Location

Loc Qty

Loc Code

LG

736

68224

2

71355

2

72704

2

72841

130

73855

600

LG001

1247

65317

1

68507

11

73390

35

73857

600

73860

600

19

D3286-3

Manufactured No

200

Each

98.0000

2

2



Spacer



B 74439 BE 11/1/02

Location

Loc Qty

Loc Code

LG001

83

74117

83

LG002

15

64564

15

D2680-041

Manufactured No

210

Each

40.0000

1

1



Nut Plate



Location

Loc Qty

Loc Code

LG

40

73334

40

73854

11-11-2

Wednesday, September 28, 2011 9:49:38 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 9:49:38 AM

Page 4

Work Order ID: 74232

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

210

Each

2,114.000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1112

114859

1112

ST318

1000

119017

1000

② 11-11-2

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

1



Washer

*



1118384 (x2) 11/11/08

CCR264SS3-3

Purchased

No

210

Each

1,399.000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

397

117086

19

117849

378

ST317

1000

119017

1000

② 11-11-2

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Page 4

W/O:		WORK ORDER CHANGES					
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Wednesday, September 28, 2011 9:49:38 AM

Page 5

Work Order ID: 74232

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



Screw



41 11/10/09

Location

Loc Qty

Loc Code

FP-A

8

1119124

41

115460

8

ST292

21

115460

21

D2651-1

Manufactured

No

270

Each

289.0000

6

6



Plug



41 11/10/09

Location

Loc Qty

Loc Code

fpa

109

1173827

46

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

D2651-3

Manufactured

No

270

Each

1,799.000

6

6



O-Ring



41 11/10/09

Location

Loc Qty

Loc Code

FP-A

1799

61962

12

66956

282

73489

505

73828

1000

46

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Page 5

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Picklist Print

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Page 6

Work Order ID: 74232

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280

Each

599.0000

14

14



Bushing



Handwritten: 11/1/08

Location

Loc Qty

Loc Code

ST084

4

B73830

68247

4

Handwritten: 11/1/08

ST088

595

64760

1

70690

47

71837

87

73399

60

73829

400

D2646

Manufactured No

280

Each

85.0000

1

1



Aft Cap



Handwritten: 11/1/08

Location

Loc Qty

Loc Code

FP004

42

68280

42

FP006

5

62678

5

B73294

Handwritten: 11/1/08

FP-4

34

70945

1

71070

33

fp5

4

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear



Handwritten: B74892 (x1) 11/1/08

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Page 6

W/O:		WORK ORDER CHANGES						
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Picklist Print

Wednesday, September 28, 2011 9:49:38 AM

Page 7

Work Order ID: 74232

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,216.000

2

2



Screw



11/4/08

Location

Loc Qty

Loc Code

ST291

1216

115108

16

117423

300

118378

400

118910

500

X7

MS21042L3

Purchased

No

280

Each

8,399.000

7

7



Nut



11/4/08

Location

Loc Qty

Loc Code

ST300

2399

117441

16

117601

240

117885

143

118451

1000

118927

1000

X7

ST516

6000

119017

6000

D3805-045

Manufactured

No

280

Each

6.0000

1

1



Wearplate Assembly Aft, Low Gear



1373819 (x1) 11/4/08

Location

Loc Qty

Loc Code

FP

6

70878

6

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2



Washer



1117087 (x2) 11/4/08

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Page 7

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Wednesday, September 28, 2011 9:49:38 AM

Page 8

Work Order ID: 74232

Parent Item: D206-642-151


Parent Item Name: Replacement Skidtube

Start Date: 10/3/2011


Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No 280 Each 261.0000 7 7

 Bolt

Location	Loc Qty	Loc Code
ST353	211	
111668	111	
118628	100	
ST354	50	
117619	50	

NAS1149D0363J Purchased No 280 Each 4,368.000 7 7

 Washer

Location	Loc Qty	Loc Code
ST298	4368	
117601	238	
118077	1130	
118612	1000	
118968	2000	

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Page 8

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

RELEASED
 09.03.03
 PC ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 1 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

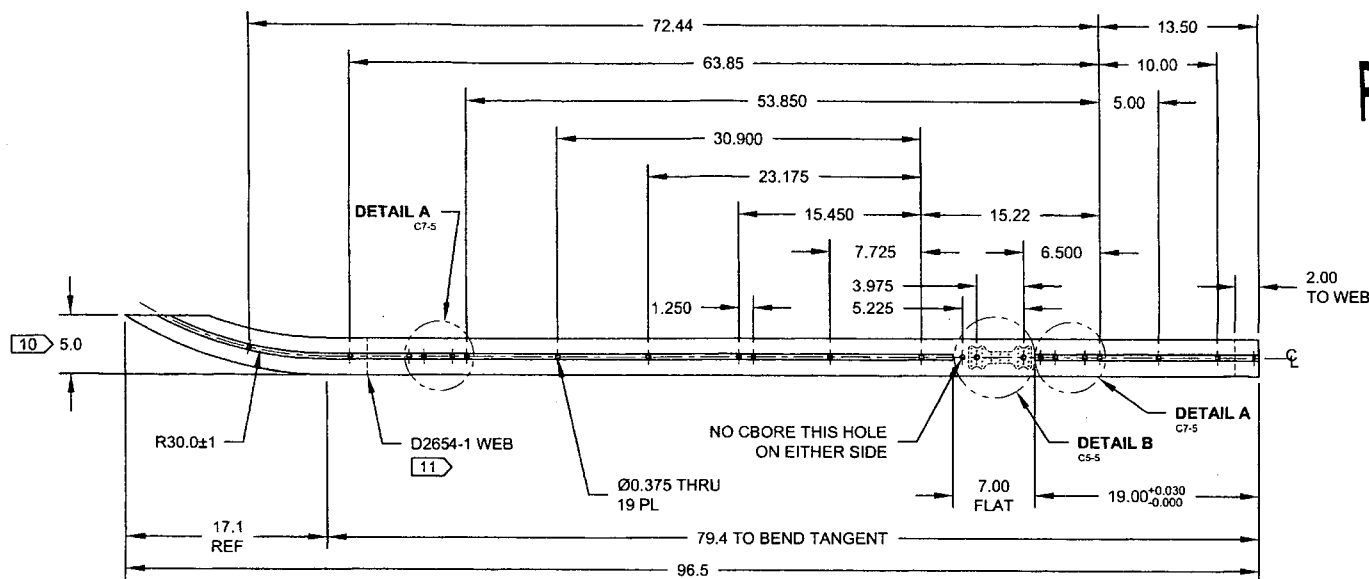
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

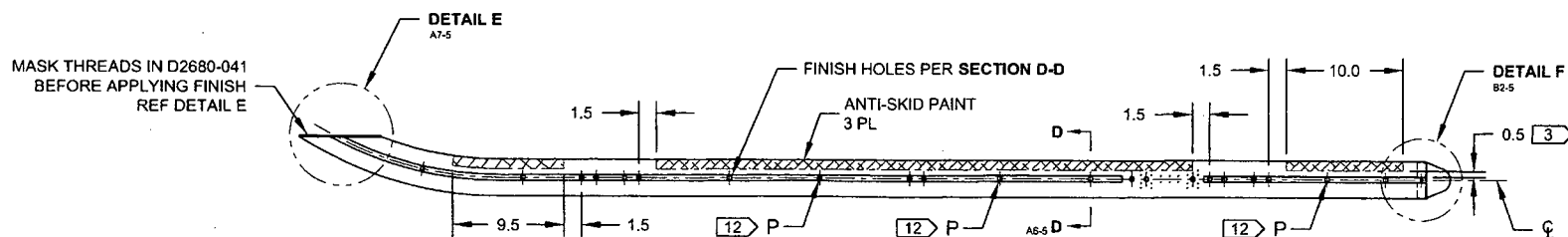
NOTE: Date & initial all entries

RELEASED
09.03.03

#74230



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 2 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#74232



DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	EE	D3804	SHEET 3 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	140	SKIDTUBE ASSEMBLY, 206A/B NT	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

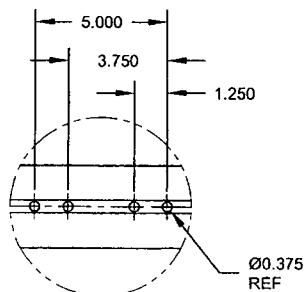
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

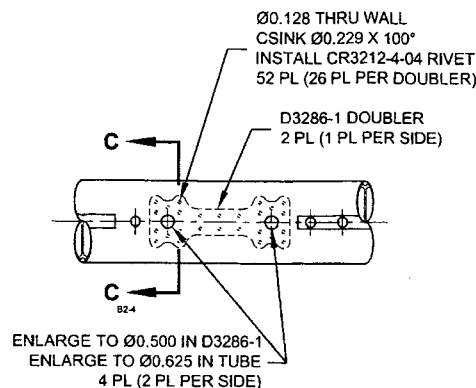
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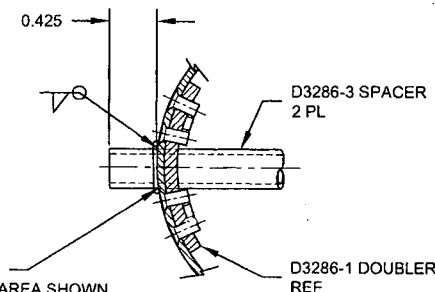
RELEASED
CP 09.03.07



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3



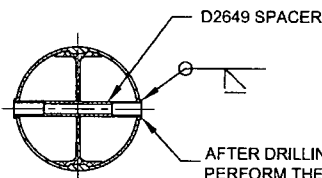
DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

#74232

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

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MFG. APPR.	EE	D3804	SHEET 4 OF 5
APPROVED	4P	TITLE	SCALE
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RELEASED
09 07 07

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE
A7-5

D2647 CAP, TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE
IN PLACE

MS27039-4-06 SCREW
AN960JD416 WASHER
D2680-041
NUTPLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

1/16

DETAIL E
SCALE NONE
B7-2
B7-3

0.400

END OF WEB

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

DETAIL F
SCALE NONE
B2-2
B2-3

#74232

DESIGN	91	DART AEROSPACE USA, INC	
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